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RBST4241-3
Job Sheet 199256



Part No: RBST4241-3

Job Qty: 4 pcs

Part Name: Retainer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/15/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST4241 Rev 1 IPP Rev. A 19.08.15 New issue DP Verify DD

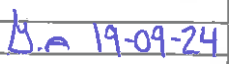
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-2500Y - 1	4 pcs	10/7/19	10/7/19	1.00	2.00	SL-2500Y - 1		SL 19-9-17
120	QC 2	4 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		JL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	Conventional Mill - 1 - B4B	4 pcs	10/7/19	0.00 1.33	Conventional Mill - 1 - B4B	
					Conventional Mill - 2 - B4B	
140	QC 2	4 pcs	10/7/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
150	QC 8	4 pcs	10/7/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	

180 Packaging 3-1 - Stock - B4B 4 pcs	10/7/19	0.00 0.00	QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
190 QC 21 - SA	4 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21
				QC 21 - SA - 70
				QC 21 - SA - 53

DA:
28
9-89DA:
21
9-89

SEP 26 2019

Part Op 110 - MORI SL2500Y LATHE) 1-Machine as per DWG. FB C981 FOLIO REV: AA DWG REV: 1

Descriptions: 2-Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - Manufacture as per dwg - Machine as per DWG

140 - QC2- Inspect parts off machine FAI/FAIB

150 - QC8- Inspect parts - second check

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

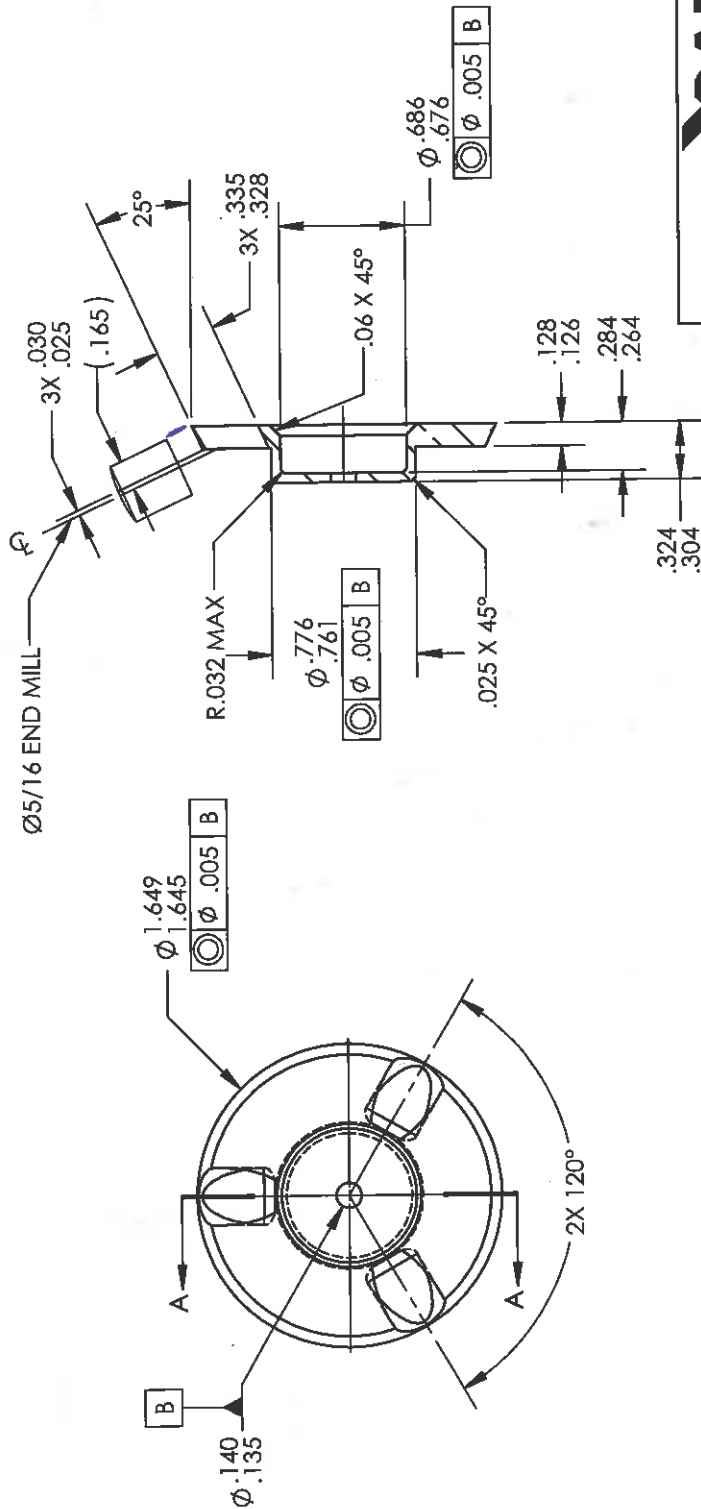
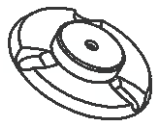
Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R2.000	Bronze C63000 Round Bar 2.000	.1400 ft (.035 ea)	110-SL-2500Y - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-2500Y - 1	MT-BRONZE-C63000-R2.000	0	4	0
Part Specifications				
Specifications could not be found.				

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REVISIONS			
REV	ECR	DATE	INITIAL



SECTION A-A

DART
AEROSPACE

TITLE
DRILL PRESS SWAGING TOOL

DWG NO. RBST4241-3 REV 1

MAT'L	BRONZE
FINISH	XXX ± .005 FRACTIONS ± 1/8
SPEC	XX ± .01 ANGLES ± 5° X ± .1 SURFACES ± 125
DRAWN BY:	DD 04/05/2017
CHECKED:	SM 04/05/2017
OPPS APPR:	AA 04/05/2017
QA APPR:	JL 04/05/2017
APPROVED:	JAG 04/06/2017
SCALE	1:1
DATE	4/5/2017
SHEET	3 OF 9

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
1. BREAK ALL SHARP EDGES
.015 X 45° OR .01R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199250 MOD 1908'K

(3)

RETAINER

1.672 min 1.665 max



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____		DISPOSITION		DEPARTMENT/PROCESS	
Part No. _____		Rework Scrap Use-as-is		Cross tube Small Fab Finishing	
		Skid-tube Machining Large Fab		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	
Date: _____		Sequence #: _____		QTY Affected: _____	
Description Work Order Deviation		Disposition		MRB (QSI042)	
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
Completed By		Lead hand / Supervisor		QC / QA Coordinator	